



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2809
Job Sheet 176432



Part No: D2809

Job Qty: 24 ea

Part Name: Washer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/24/18

Job Tracking No:

Due Date: 5/4/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A1 IPP C 02.03.07 Now turned in house NG IPP REV:D 11.12.08 added powdercoat per dwg DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	24 Ea	5/4/18	5/4/18	0.00	0.00	Start Up Machining-1		SL 18/05/17
100	Hardinge	24 pcs	5/4/18	5/4/18	0.09	2.23	Hardinge		SL 18/05/17
120	QC	24 pcs	5/4/18	5/4/18	0.00	0.00	QC8		PM 18/05/22
125	HandFinish	24 pcs	5/4/18	5/4/18	0.00	0.40	HandFinish1		SA 18-05-22
130	Powdercoat	24 pcs	5/4/18	5/4/18	0.00	0.38	Powdercoat1		BL 18-5-25
160	QC	24 pcs	5/4/18	5/4/18	0.00	0.00	QC3		MAY 25 2018
170	Packaging	24 pcs	5/4/18	5/4/18	0.00	0.00	Packaging3-1		GA 17 18-05-30
180	QC21-SA	24 Ea	5/4/18	5/4/18	0.00	0.00	QC21		

Part Op 100 - Machine as per Folio FA204

Descriptions: 170 - LOCATION : GA

M 138834 START: 9:20 OUT: 3:00 FINISH: 9:50

MAY 30 2018
2 MAY 3 9:28

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R0.563	6061-T6 Round Bar .563	2.3880 ft (.0995 ea)	90-Start up Operation	S072529

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R0.563	2	116	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Spacer	0.191inches + 0.005 - 0.000	0.196 0.191	.191	
2	Spacer	0.313inches + 0.005 - 0.000	0.318 0.313	.314	
3	Spacer	0.500inches ± 0.005	0.505 0.495	.499	
4	Spacer	0.359inches ± 0.010	0.369 0.349	.360	
5	Spacer	1.194inches ± 0.010	1.204 1.184	1.197	
6	Spacer	0.040inches ± 0.010	0.050	.04	

M6061T6R0.563
S046349

S046349 L.Y.

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																																																	
Description Work Order Deviation			Disposition																																																		
			Completed By																																																		
			Lead hand / Supervisor Approval Verification																																																		
			QC / QA Coordinator Approval																																																		
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr><td>Environment</td><td>☐</td><td>No Re-verification</td><td>☐</td></tr> <tr><td>Design</td><td>☐</td><td>Operator</td><td>☐</td></tr> <tr><td>Doc/Data</td><td>☐</td><td>Offset/Setup</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td><td>Supplier</td><td>☐</td></tr> <tr><td>Handling/Pre</td><td>☐</td><td>Training</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td><td>Use for Testing</td><td>☐</td></tr> <tr><td>Internal Transport</td><td>☐</td><td>Poor Information</td><td>☐</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td><td>Rushing</td><td>☐</td></tr> <tr><td>LOA</td><td>☐</td><td>Product Improvement</td><td>☐</td></tr> <tr><td>Substation</td><td>☐</td><td>Process Improvement</td><td>☐</td></tr> <tr><td>Past Expiry Date</td><td>☐</td><td>Manufacturing Process</td><td>☐</td></tr> <tr><td>Misidentified</td><td>☐</td><td>Past Due</td><td>☐</td></tr> </table> DART Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 822-5200 Email: sales@dartaero.com www.dartaero.com Container No: S072531 Part: D2809 Job No: 176432 Serial No/Batch: S072531 Revision: _____ Inspector: _____ Date: 06/17/18						Environment	☐	No Re-verification	☐	Design	☐	Operator	☐	Doc/Data	☐	Offset/Setup	☐	Equip/Tooling	☐	Supplier	☐	Handling/Pre	☐	Training	☐	Material	☐	Use for Testing	☐	Internal Transport	☐	Poor Information	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐
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OTHER : _____			ge ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect illed ☐ Part Lost/Missing e ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence																																																		

			0.030	
7	Spacer	45.000Degrees ± 0.000	45.000 45.000	45°
8	Spacer	0.020inches ± 0.010	0.030 0.010	.020

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					